

Date: Thursday, 5/31/2007 7:20:07 AM  
User: Kim Johnston

## Process Sheet

*split*  
*SB 07/06/11*

*24*

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HELI-ACCESS STEP LH (FOLDING)		
Job Number	32713			Part Number	D412630033		
Estimate Number	12567			Drawing Number	IIN D412-630 REV K		
P.O. Number	<i>N/A</i>			Project Number	N/A		
This Issue	5/31/2007	S.O. No.	<i>N/A</i>	Drawing Revision	K		
Prsh Rev.	NC			Material	<i>N/A</i>		
First Issue	<i>N/A</i>	Type	LARGE FAB ASSY	Due Date	6/11/2007	Qty:	<i>3</i>
Previous Run	31459			Um:	Each		
Written By	<i>[Signature]</i> 07.05.31						
Checked & Approved By							
Comment	Est. Rev:A New Issue 06-11-08 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description:			
1.0	DC			DOCUMENT CONTROL			
Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG002							
2.0	D2012107			Clevis			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch 1 D2012-107 Clevis <i>B29643</i>							
3.0	D2803041			Bracket Assembly			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2803-041 Bracket Assembly LH <i>(2) B29391</i>							
4.0	D2804041			Bracket Assembly			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch 1 D2804-041 Bracket Assembly LH <i>(1) B27102 (2) B27284</i>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	18	Split w/o	SS	07/06/11	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Pick:

Qty	Part Number	Description	Batch
2	D2807	Gas Spring	<i>B28488</i>

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
2	D2813	Washer	<i>B25923</i>

7.0

D3562041

STEP ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description	Batch
1	D3562-041	Step Weldment LH	<i>B 32718</i>

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<i>B27291</i>

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<i>① 7/6/458 M101189, 5x 1419633</i>

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

18779

(3x)

(4x)

M100695

11.0 AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M100433

(3x)

(3)

M102728

12.0 MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941

13.0 NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633

(6)

(12)

M100993

14.0 NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M101925

(10x)

(2)

M103286

7/6/458

## Process Sheet

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Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

15.0 NAS1515H8 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	M102067

16.0 MS210433 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
4	MS21043-3	Nut	M103286

(1)   
 (2)   
 M103691

17.0 MS24693C280 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
2	MS24693-C280	Screw (or MS24694-C565)	M101390

7/6/430

18.0 SMALL FAB 1 SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M101472

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: M17045

MF 01-06-12

(1)

19.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/12

(1)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-1

Bushing

② B27285

③ B28162

① B29393

22.0 D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

② B28163

④ B29394

23.0 D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

① B27287 ✓ ② B28103

24.0 D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

① B27290 ✓

25.0 AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

① B102039

② 7/6/4 SP

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M100273

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M101291

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M19620

(1) (2) ✓  
M101711 1X

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M100229

✓  
M100229 ✓

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M101429

✓  
7/6/07 SP

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 32713

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation:

Description :

31.0 NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

\*② ✓

19

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M101925

M102728

32.0 MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

✓

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M104537

33.0 MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

✓

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M101415

✓ 7/6/4 ED(3)

34.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

(1) 07/06/11=①

35.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

① 07/06/12

Identify and pack for shipping as per PPP D412-630-033

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev 0 7/6/22 S0

36.0 QC21

FINAL INSPECTION/W/O RELEASE



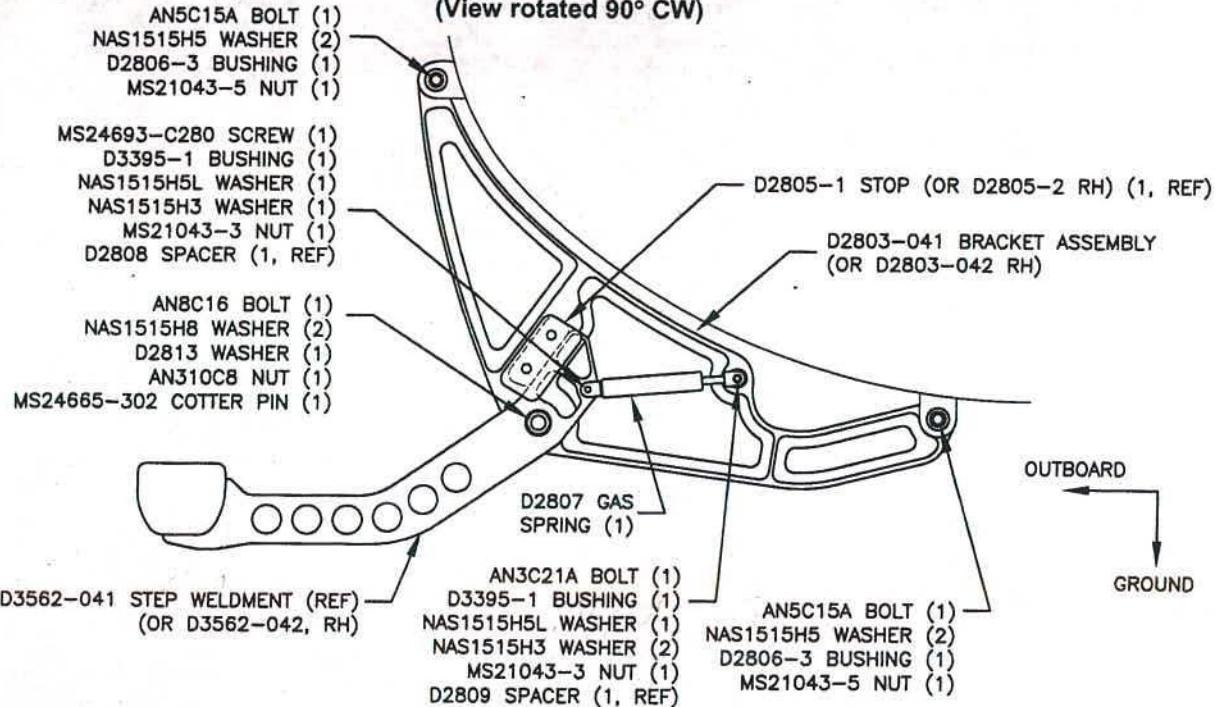
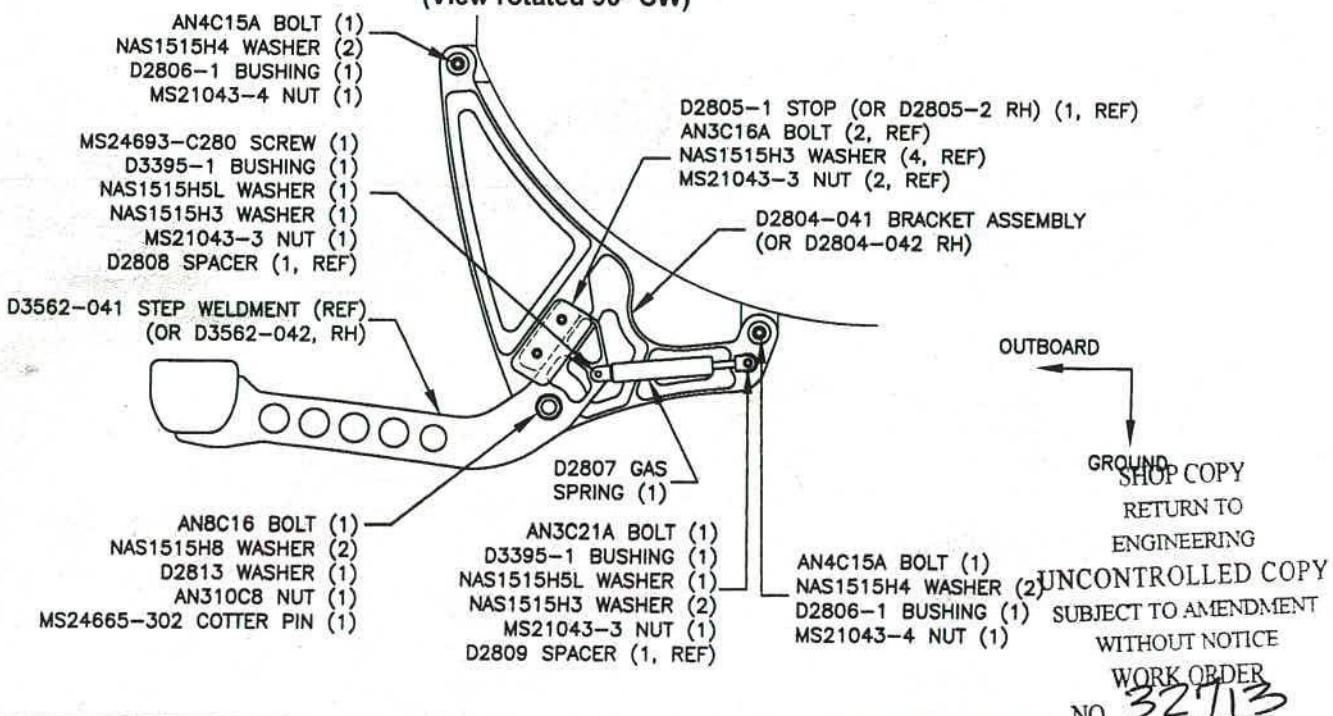
Comment: FINAL INSPECTION/W/O RELEASE

(1) 07/06/12

Job Completion



W 07/06/12

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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